

Work Order ID 70751

Tuesday, June 14, 2011 10:44:02 AM



Page 1

Item ID: D4277-11

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 6/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-06-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4277

D

100

0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut tube at 26.00" with the 45 degree angle
- 2- Remove marking
- 3- On manual bender, bend as per dwg
- 4- Cut to size, 63 degree as per dwg
- 5- Deburr

SAD 11-06-14

2

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

11.06.14 2

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Page 2

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Start Date: 6/14/2011 Start Qty: 2.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

STOCK IN BASKET CELL

11-06-14 ②

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15
ME
11-06-14

Picklist Print

Tuesday, June 14, 2011 10:44:00 AM

Page 1

Work Order ID: 70751



Parent Item: D4277-11



Parent Item Name: Rib

Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

872.2836

2.1666

4.561263



SAD 11-06-17

Square Tubing

Location

Loc Qty

Loc Code

MAT034

872.2836

116610

0.8383

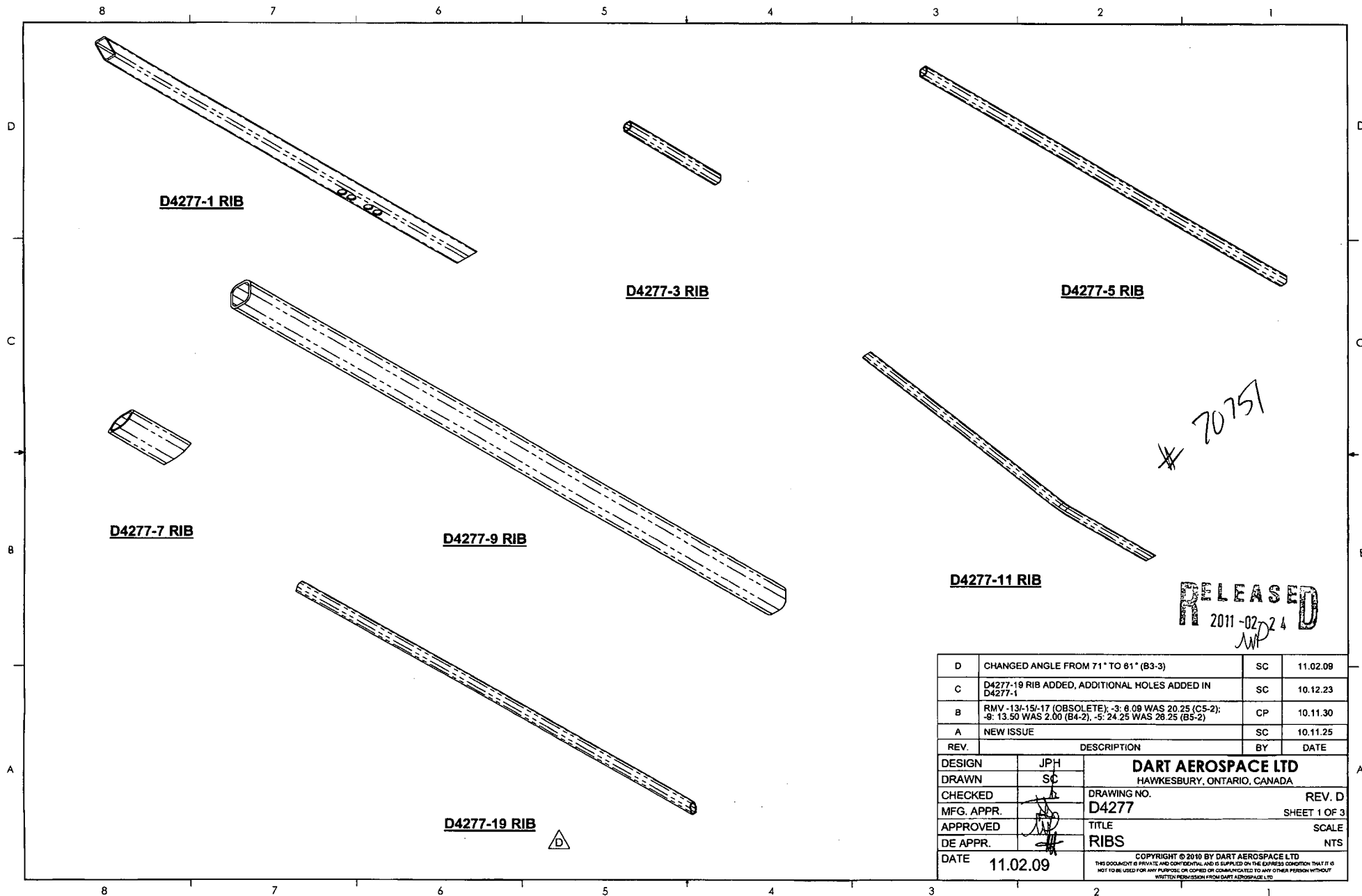
117721

267.4453

117999

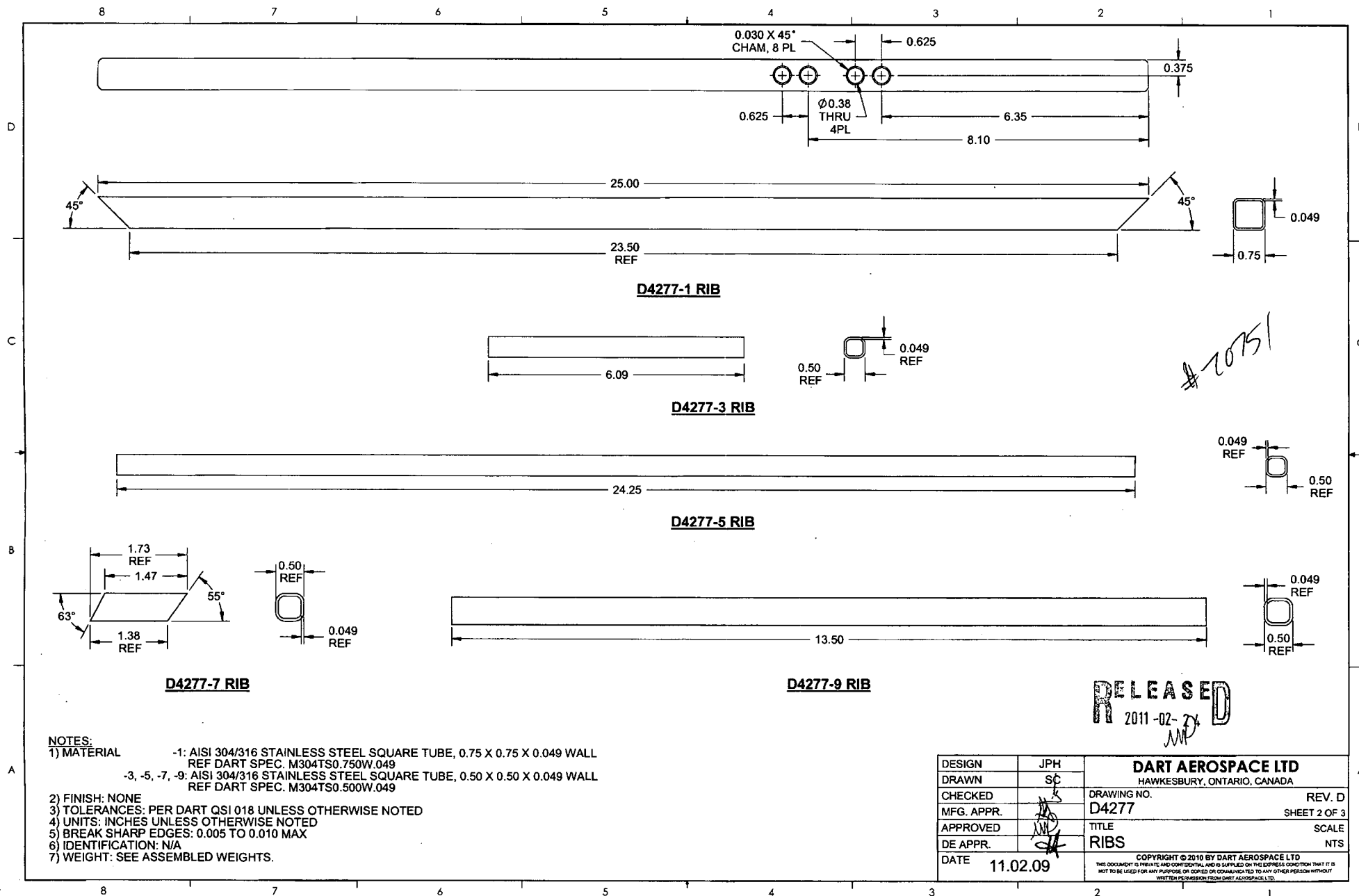
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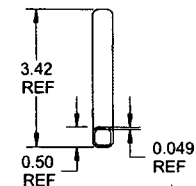
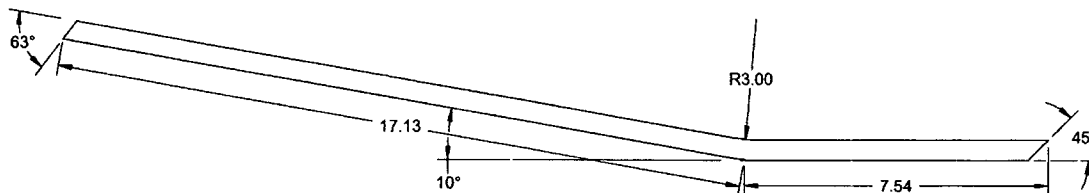
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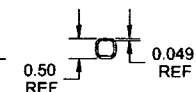
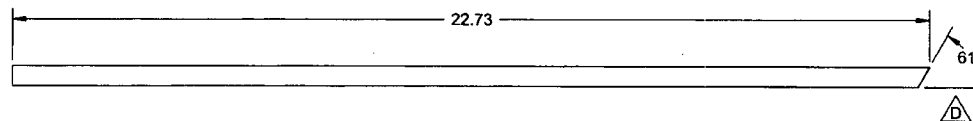
RELEASED
2011-02-24
MP

D	CHANGED ANGLE FROM 71° TO 61° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV - 13/15/17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -6: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	h	DRAWING NO.	REV. D
MFG. APPR.	h	D4277	SHEET 1 OF 3
APPROVED	h	TITLE	SCALE
DE APPR.	h	RIBS	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





D4277-11 RIB



D4277-19 RIB

#70751

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4277	SHEET 3 OF 3
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DE APPR.		RIBS	NTS
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